

Date: Friday, 7/4/2008 8:46:48 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206 L WEB		
Job Number	40249					
Estimate Number	10722					
P.O. Number	:		Part Number	D26547		
This Issue	: 7/4/2008	S.O. No. :	Drawing Number	D2654 REV E1		
Prsht Rev.	: NC		Project Number	N/A		
First Issue	: / /	Type : SKIDTUBES	Drawing Revision	E1		
Previous Run	: 39884		Material	:		
Written By	:	108 07 04	Due Date	: 7/20/2008	Qty:	4 Um: Each
Checked & Approved By	:					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM					
	Est Rev:e 06.04.05 Added level21		EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26007140	EXT. "I BEAM" THICK	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty	Part Number	Description
	1	D2600-7- 140	Web
			21966
			BT 06-07-15
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-7 to length as per Dwg D2654	
		2-Drill pilot holes in web using drill jig DT 8018-7 as perDwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	
		4-Deburr holes and ends	BT 06-07-15
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	SO8/07/15 44
			BT 06-07-15
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	
			BT 06-07-15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 40249		Part Number: D26547
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
6.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Identify and Stock Location: <u>Skid tube cell</u> S 08/09/15 (xc)
7.0	QC21	FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE RF 08-02-15
Job Completion		MF 08-07-15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

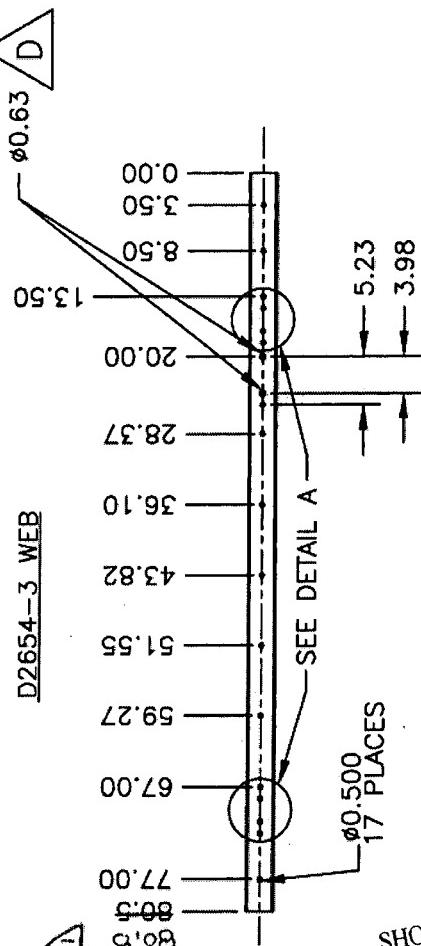
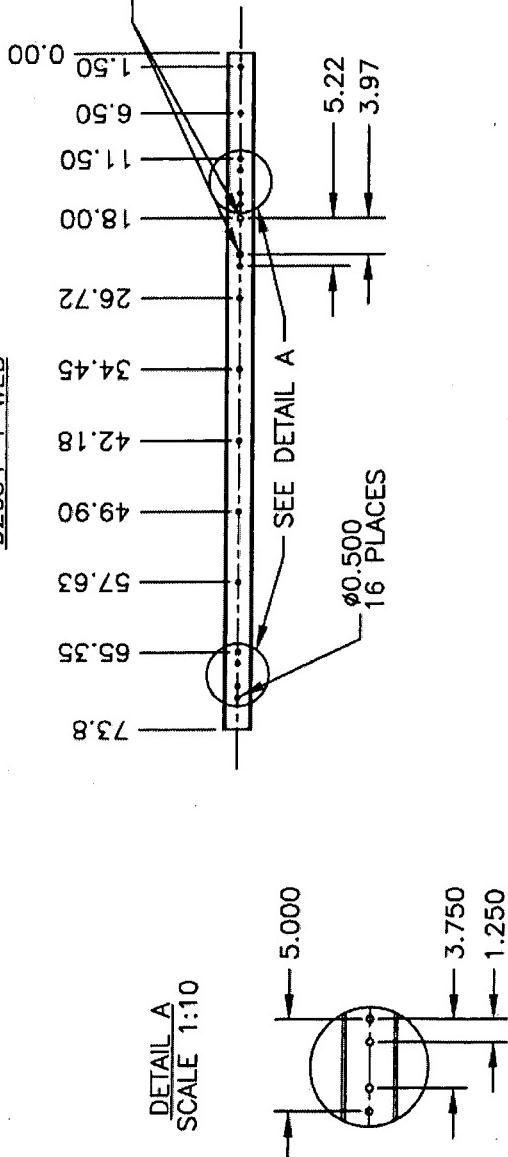
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE	TITLE	SCALE
04.05.26	WEB	1:20
A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO Ø0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.24	PER TOOLING; 80.8 WAS 80.5

RELEASED
04.06.22

D2654-1 WEB



SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 40249

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

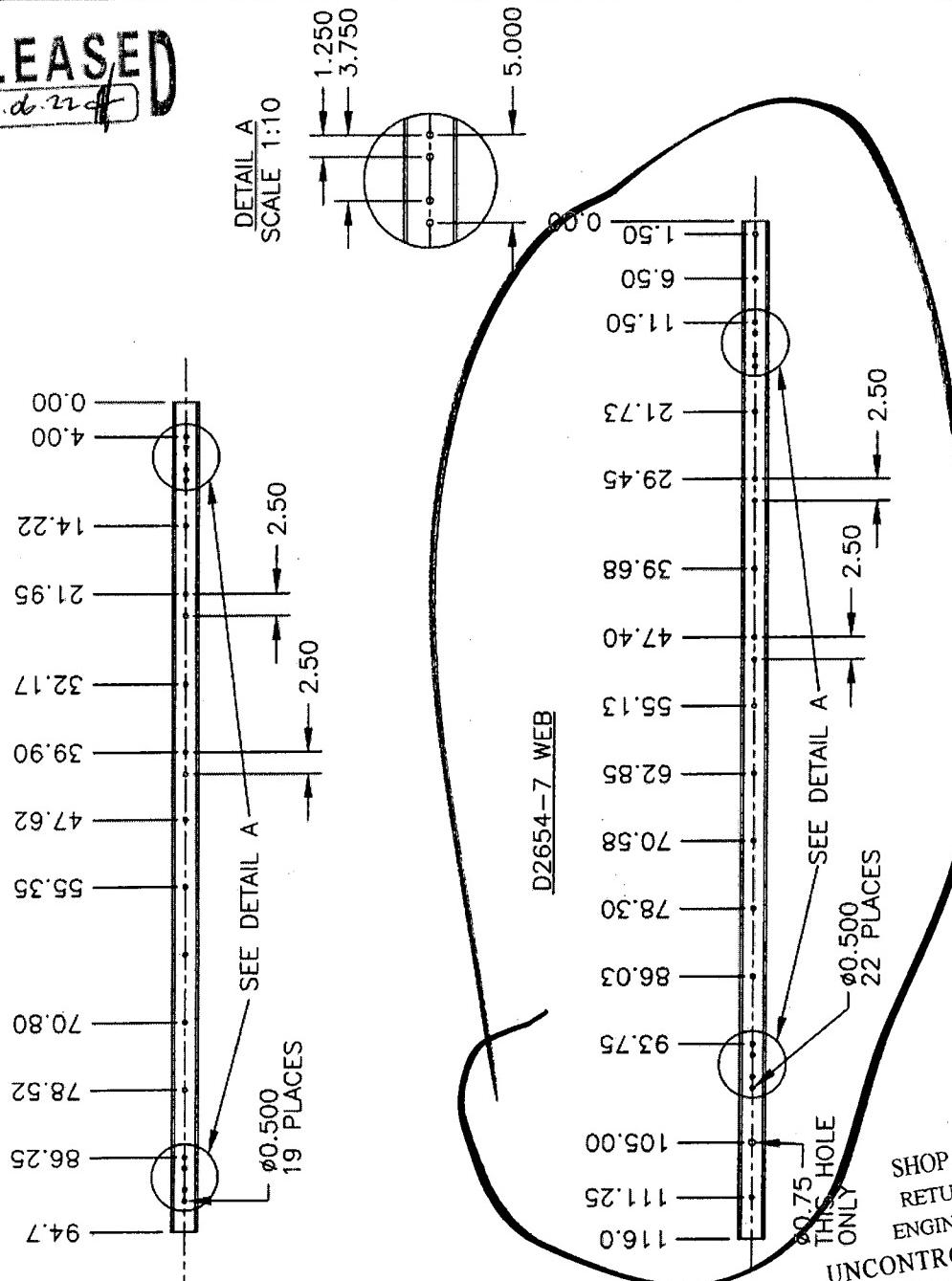
DARTO/COPY
3/26/97

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2654 REV. E
DATE		SHEET 2 OF 2

04.05.26 TITLE WEB SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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